

Work Order ID 67194



Page 1

Thursday, March 10, 2011 8:47:48 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-03-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3272	Rev B								

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								

110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod								
	3-Grind End Plate flush								

[Handwritten signature]
[Handwritten date: 11-03-30]
[Handwritten initials: 10]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 0 BE11/03/31

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 u603/30

10 RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 RH 6 11/03/31

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BK 11-3-31

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod M114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11.04.04

10

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC10- Inspect visual per QSI004- ground welds

0.00



Sunday

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



Sunday

QC

Memo

0.00

Quality Control

*NO
PM*

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BK 11-4-5.

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 115951</i> Memo START TIME: <i>1:20</i> OVEN TEMPERATURE: <i>3200</i> FINISH TIME: <i>1:50.</i>	0.00 0.00				<i>10.</i>		<i>11-4-5</i>	
230 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 11731</i> Memo	0.00 0.00						<i>10846</i>	<i>M 1104/06</i>
240 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>11/4/11</i>	<i>170</i>

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date:	3/18/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260 	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location:								

Rev B

11/4/11 SL

11 04 12 10

11/4/12 SL 12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12 [Signature]
11-04-12
(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 67194

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 Step		Manufactured	No			110	Each	20.0000	1	10			
-----------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA	20	
66623	10	
66624	10	

D3067-1 End Plate		Manufactured	No			110	Each	128.0000	1	10			
----------------------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA	128	
65969	128	

D3219-1 Plate		Manufactured	No			110	Each	116.0000	2	20			
------------------	--	--------------	----	--	--	-----	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
WA	116	
66133	116	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 67194



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

113.0000

2

20



Spacer



11.04.02

Location

Loc Qty

Loc Code

WA

113

65072

6

66131

107

20

MS20600-AD4W4

Purchased No

180 Each

2,263.000

16

160



Rivets



11.04.04

Location

Loc Qty

Loc Code

ST321

2263

113368

38

114181

11

114718

2

115573

70

115640

31

116022

4

116188

1500

116712

607

965

D3065-041

Manufactured No

180 Each

57.0000

1

10



Step Leg Assembly Hi



11.04.02

Location

Loc Qty

Loc Code

WA

57

63554

17

66149

40

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

D3067-1

Manufactured No

180

Each

128.0000

1

10



End Plate



11.04.04

Location

Loc Qty

Loc Code

WA

128

65969

128

Purchased

No

250

Each

118.0000

2

10

20

AN3-35A



X₁₀ Bolt



11/4/11

Location

Loc Qty

Loc Code

ST353

118

116191

78

117094

40

Manufactured

No

250

Each

47.0000

2

20

D3235-1



X₁₀ Mounting Lug



20

366941

sl

Location

Loc Qty

Loc Code

ST471

47

65073

47

Manufactured

No

250

Each

35.0000

1

10

D3278-041



X₁₀ Support Assembly



11/4/11

66946

Location

Loc Qty

Loc Code

ST471

35

66155

35

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Shop Packet Print

Page 3

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Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased

No

250 Each

30.0000

16

160



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6



1117065

sl

AN960JD516 NAS1149D0563J Purchased

No

250 Each

34.0000

4

40



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4



1116702

sl

AN5-36A Purchased

No

250 Each

137.0000

2

20



Bolt

Location

Loc Qty

Loc Code

ST341

137

114292

1

116191

1

116549

35

116704

100



11141150

100

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Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

D2618 Manufactured No

250

Each

63.0000

2

20



Bushing



B66942 11/4/11

Location

Loc Qty

Loc Code

ST019

63

65071

3

66132

60

D2230-3 Manufactured No

250

Each

12.0000

4

40



Lug



B67763 11/4/11

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

8

55452

2

66126

6

D2856-400 Manufactured No

250

f

146.2980

1.2

12



Abraison Strip



11/4/11 12

Location

Loc Qty

Loc Code

ST403

146.2980421

56626

0.00004211

59920

43.381

63735

102.917

cut (2) D2856-400-720 as per dwg

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Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L3

Purchased

No

250

Each

2,376.000

2

20



Nut

Location

Loc Qty

Loc Code

ST300

2376

116391

776

116540

800

116549

800

20

AN4-13A

Purchased

No

250

Each

592.0000

8

80



Bolt

Location

Loc Qty

Loc Code

ST357

592

116786

292

117094

300

80

MS21042L5

Purchased

No

250

Each

970.0000

2

20



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

944

115594

248

116105

496

116548

200

20

Dart Aerospace Ltd

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Required Date: 3/18/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

4,376.000

8

80



Nut

Location

Loc Qty

Loc Code

ST300

4376

1123143

2

115589

10

115621

20

116188

2344

116823

2000



11/4/85

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

24.0000

4

40



Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

18

105792

2

112279

16



11/6/83

SL

182

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Shop Packet Print

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DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

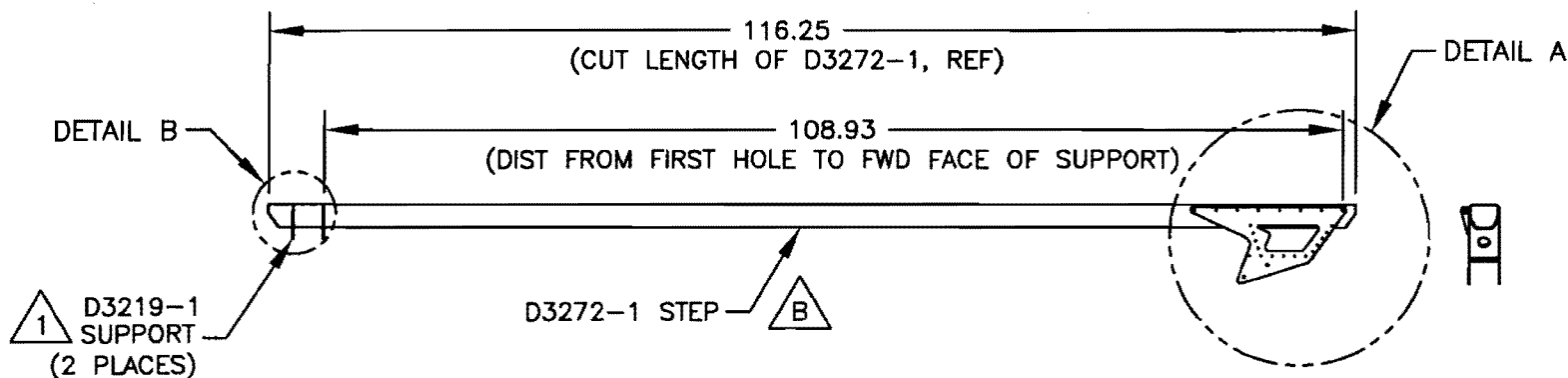
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

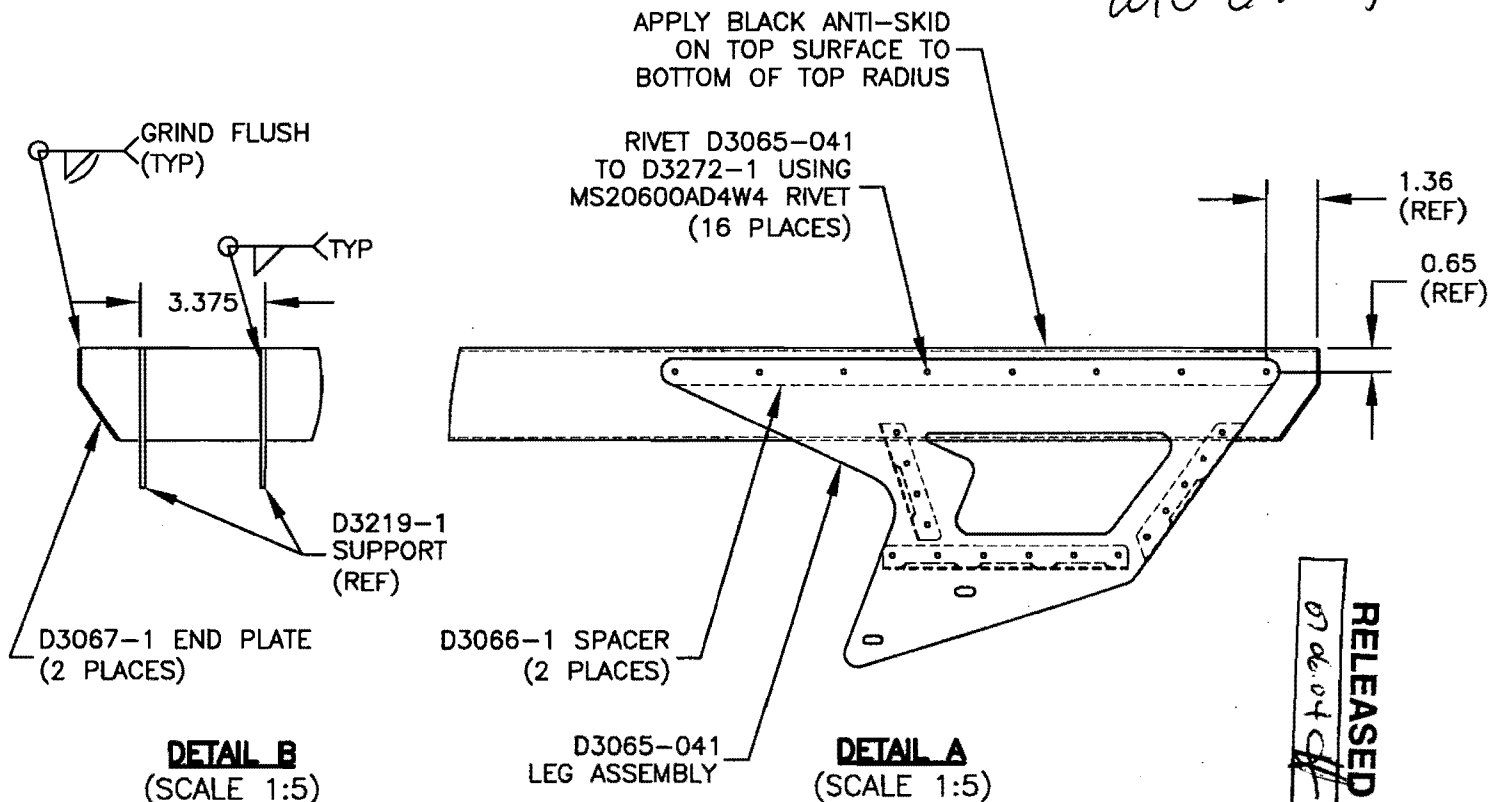
DART

DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD
CHECKED	CE	APPROVED	CE	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	TITLE	D3272	REV. B
			STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

w/o 67194



RELEASED
07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

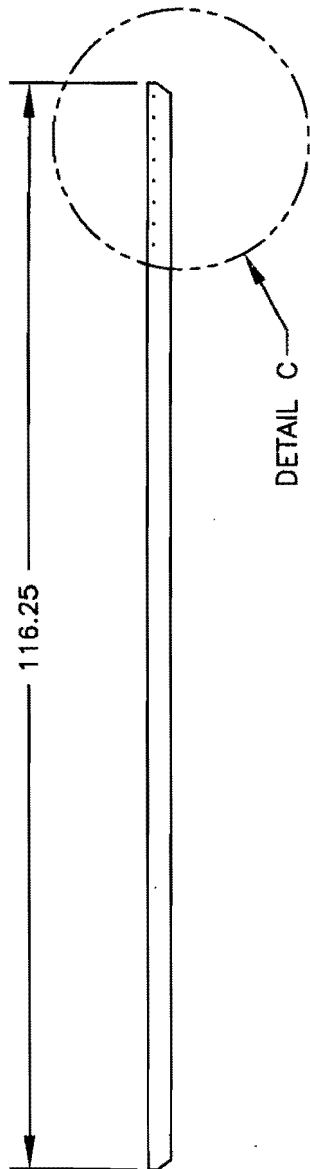
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>js</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

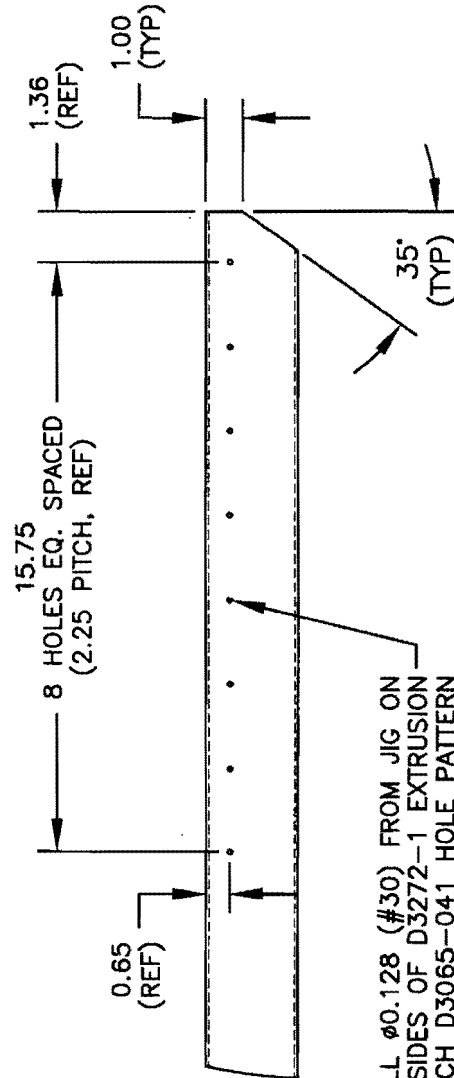


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

wb 61194



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

C
(SCALE 1:5)

RELEASED

07.06.04 *js*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

M 11 04-12

D350-591

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	*D2856-400-720*	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	*D3278-041*	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G
Date: 08.10.06

